

Work Order ID 55926

February 4, 2010 2:38:14 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *BT*

Date: 10-2-04 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

*S. Colas/02**H. G. CL 10/03/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-636-011

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Start Date: 2/04/10 Start Qty: 1.00



Required Date: 2/12/10 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod

M13207

10-Grind welds flush as per Dwg D2750

A 10/2/9

3 BE 10/2/09

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NOTE: Date & initial all entries

Work Order ID 55926

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Item ID: D350-636-011

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Cust Item ID:

Customer:

Reference:




Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	12- Scribe batch# inside per dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
 QC Quality Control	Memo	0.00							
130	QC5- Inspect part completeness to step on W/O	0.00							
 QC Quality Control	Memo	0.00							
140	Chemical Conversion Coat per QSI005 4.1	0.00							
 HandFinish Hand Finishing	Memo	0.00							

H 10/2/09

S 10/02/09

S 10/02/09

④

P

25 10/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D350-636-011

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Revision ID:

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Stop



Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-2-9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D350-636-011

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Item Name: Skidtube LH

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Start Date: 2/04/10 Start Qty: 1.00



Required Date: 2/12/10 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QS1 015

A/R ☐ ☐ Sikaflex-291 batch: M112419 ☐ ☐
exp. date: 10/18/10

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QS1004
(welding instructions on sheet 8)

A/R ☐ ☐ Aluminum Rod batch: M113207

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

BE 10/02/09

M 10/2/9

BE 10/2/10

M 10/2/11

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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes

1 4/6/2/17

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

~~8/10/2/15~~ 8/10/2/22

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

~~8/10/2/15~~ 8/10/2/22 (X)

W/O:		WORK ORDER CHANGES					
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Required Date: 2/12/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

PAR 09-043 BR 10-03-1.

0.00



HandFinish

Memo

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

BR 10/03/02

0.00

XL 9



Powdercoat

Memo

START TIME: 8:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30AM

Powder Coating

210

QC3- Inspect Part Finish

0.00

BR 10-3-5

0.00

Q.



QC

Memo

Inspect for foreign object per QSI 024

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 55926

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Item ID: D350-636-011

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Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

10-3-5

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 101235

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: 104251

0.00

0.00

10-3-5 D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 55926

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Item ID: D350-636-011

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Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 10/03/08

(70)

250



Packaging

Packaging

Pick Kit

0.00

0.00

Memo

10-3-8 SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

Memo

S 10/03/09

(70)

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 55926

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Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
	<i>MUH</i>								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Rec'd B/11 (1)**10/03/16**MF**10-3-11*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

D2594-3

Manufactured No

230

Each

700.0000 8.0000



O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

527

51613

27

55546 ✓

500

Main Warehouse

ST

173

52562

173

D2744

Manufactured No

110

Each

51.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

51

44892

1

47488

23

51922

27

8 10-3-5

1 88 10/02/09

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D2600-3-BENT

Manufactured No

110 Each

17.0000 1.0000



Extrusion Bent

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

12

50675

2

55462

10

Main Warehouse

ST

5

43495

1

47133

1

52346

3

D2743

Manufactured No

160 Each

227.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

52

50281

50

51913

2

Main Warehouse

ST

175

44891

2

45555

17

48275

1

52310

155

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Shop Packet Print

Page 2

1 M 10/2/10

8 BE 10/2/10

W/O:		WORK ORDER CHANGES					
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Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D2739

Manufactured No

160 Each

5.0000 1.0000



350 I Beam

Warehouse

Location

Main Warehouse

ST

5

47124

1

53900

2

55034

1

55569

1

Loc Qty

Loc Code

B55976

1 1/10/2/9

D3490-3

Manufactured No

160 Each

69.0000 4.0000



Cross Bolt Spacer

Warehouse

Location

Main Warehouse

LG

60

55010

60

Main Warehouse

ST

9

45560

1

48276

4

51930

4

Loc Qty

Loc Code

4 BE 1/10/2/10

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Shop Packet Print

Page 3

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Start Qty: 1.00

Required Qty: 1.00

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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3490-1 Manufactured No 160 Each 52.0000 4.0000



Cross Bolt Spacer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	52	
45338	2	
47657	2	
48277	9	
51932	39	

ALS4-1032-225 Purchased No 220 Each 6,420.000 38.0000



Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6420	
107441	16	
110768	6404	

[Handwritten signature]

2 BE 10/02/10
2 BE 10/02/10

38. DR 10-3-5

February 4, 2010 2:37:31 PM

Shop Packet Print

Page 4

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3492-041

Manufactured No

230 Each

121.0000 8.0000



Plug Assembly

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST 121

51584 44

55446 ✓ 77

D3793-3

Manufactured No

230 Each

10.0000 1.0000



Wearshoe

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST 10

51592 ✓ 10

AN8C35A

Purchased No

230 Each

131.0000 1.0000



BOLT

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST 131

102180 1

106896 1

110105 48

110847 ✓ 81

8. BR 10-35

1 BR 10-35

1 BR 10-35

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3793-1

Manufactured No

230 Each

15.0000 1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

40551 ✓

1

51597 ✓

14

D3488-041

Manufactured No

230 Each

11.0000 1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

47348 ✓

11

1 BR 10-3-5

1 BR 10-3-5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3794-3

Manufactured No

230

Each

15.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51598	2	
51907 ✓	10	
Main Warehouse		
ST	3	
46531	2	
47440	1	

1 PR 10-3-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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February 4, 2010 2:37:32 PM

Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

AN6C44A

Purchased

No

230

Each

116.0000 4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	114	
110105	4	
110155	14	
110665	1	
111605 ✓	42	
111649	50	
112720	1	
113121	2	

4. 10-3-5

MS21083C8

Purchased

No

230

Each

78.0000 1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
110584	5	
111424	2	
113149 ✓	21	
113845	50	

1 10-3-5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07-13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

D3536-25

Manufactured No

230 Each

33.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP10 28

51607 2

54479 26

Main Warehouse

ST 5

45569 1

47011 2

47526 2

D3631-1

Manufactured No

230 Each

394.0000 8.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 394

52693 94

54388 300

1 BR 10-3-5

8 BR 10-3-5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

February 4, 2010 2:37:40 PM

Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3791-1

Manufactured No

230 Each

5.0000 1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

51610

2

2

Main Warehouse

ST

51909

3

3

AN960C10L

Purchased

No

230 Each

388.0000 38.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

103585

100

100

Main Warehouse

ST

112116

112612

288

128

160

NAS1149C0332R.

118737

1 BR 10-3-5.

38. BR 10-3-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

D2745

Manufactured No 230 Each 298.0000 8.0000



Bushing

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		36	
43754		2	
44893		33	
45556		1	
Main Warehouse			
ST023		23	
34817		2	
36230		8	
37303		1	
39587		2	
40726		2	
41114		2	
42778		6	
Main Warehouse			
ST46		239	
51537 ✓		54	
51910		4	
52311 ✓		181	

2
6 PR 10-3-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 4, 2010 2:37:46 PM

Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ

IPP Rev: J 06-03-23 As per Rev D JLM

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 2/04/10

Start Qty: 1.00

Required Date: 2/12/10

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

706.0000 34.0000



Bolt

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

706

8

69

1

214

300

114

111424

111707

112314

113121

113149 ✓

113644

230

Each

90.0000 3.0000

D3537-I

Manufactured

No



Wearpad

WarehouseLocation

Main Warehouse

FP

48288

Main Warehouse

FP17

51678

51679 ✓

Loc QtyLoc Code

2

2

88

1

87

34.0000 10-3-5.

3 10-3-5.

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By:EC

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased

No

230

Each

216.0000 1.0000



WASHER

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424 ✓

81

230

Each

95.0000 8.0000

D3492-043

Manufactured

No



Plug Assembly

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

91

54682 ✓

91

Main Warehouse

ST

4

52309

4

1 BR 10-3-5

8 BR 10-3-5

February 4, 2010 2:37:51 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 778.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 778

111982 ✓ 778

NAS1611-013 Purchased No 230 Each 142.0000 8.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 100

113743 100

Main Warehouse

ST 42

106513 11

111424 20

111758 ✓ 11

4 BR 10-3-5

8 BR 10-3-5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 2/04/10

Start Qty: 1.00

Required Date: 2/12/10

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

8.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

56065
51927

2

2

Main Warehouse

ST

52589

6

6

230

Each

21.0000

1.0000



1 BH 10-3-5

D3794-1

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

51928 ✓

55459

18

6

12

Main Warehouse

ST

46530

47212

3

1

2

1 BK 10-3-5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 976.0000 4.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	976	
112314	976	

D3493-1 Manufactured No 260 Each 41.0000 2.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
44902	2	
47710	39	

MS21083C8 Purchased No 260 Each 78.0000 2.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
110584	5	
111424	2	
113149	21	
113845	50	

4 Bl 10-3-5.
10-3-8 SP

10-3-8 SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

AN8C21A Purchased No 260 Each 130.0000 2.0000



BOLT



10-3-8 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

Location	Qty
ST	130
105160	1
107596	1
107924	2
109092	2
110341	2
110342	2
111605	50
112720	20
113558	50

AN960C816L Purchased No 260 Each 216.0000 2.0000



WASHER



10-3-8 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

Location	Qty
ST	216
104093	2
107520	4
110139	29
110584	100
111424	81

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments:

IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

D3672-1



Phenolic Washer

Manufactured No 230 Each 1,720.000 4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1220	
39275	19	
42329	5	
47628 ✓	196	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

H. Br 10-3-5.

D2741



Blade, 350 Skidtube

Manufactured No 260 Each 24.0000 1.0000



10-3-18 \$

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	24	
51931	24	

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 4, 2010 2:38:08 PM

Page 19

Work Order ID: 55926

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 2/04/10

Required Date: 2/12/10

Start Qty: 1.00

Required Qty: 1.00

D3532-1



Manufactured No 260 Each 68.0000 2.0000

Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 68

44904 2

52321 66

Purchased No 260 Each 934.0000 2.0000

D3672-13



Phenolic Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 934

54363 934

February 4, 2010 2:38:08 PM

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Page 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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BAO-2-04

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3536-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-6, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCH 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H4L, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RA</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>RA</i>		
CHECKED	<i>AK</i>	DRAWING NO. D2750	REV. F SHEET 1 OF 11
MFG. APPR.	<i>AK</i>	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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DE APPR.	<i>AK</i>	DATE 08.07.16	

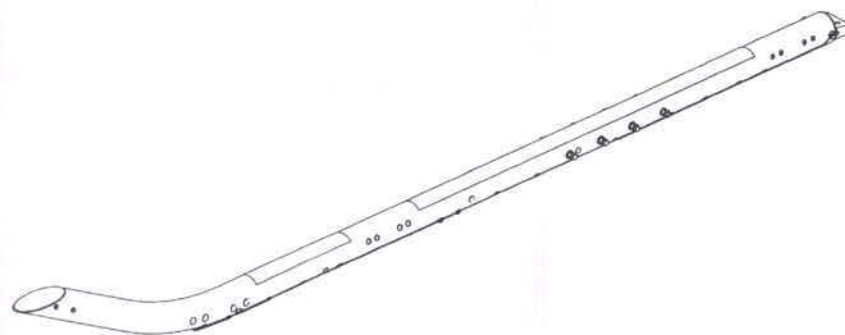
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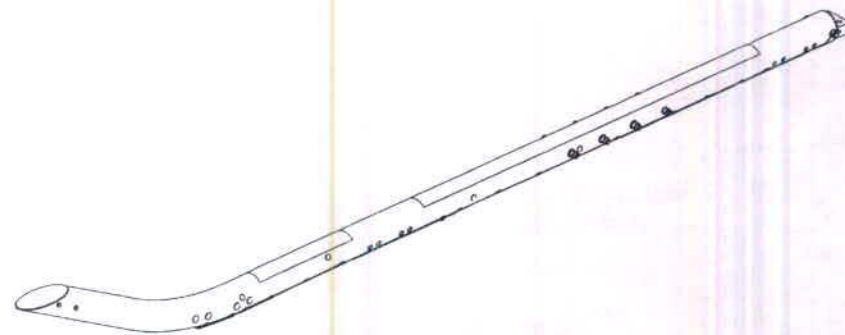
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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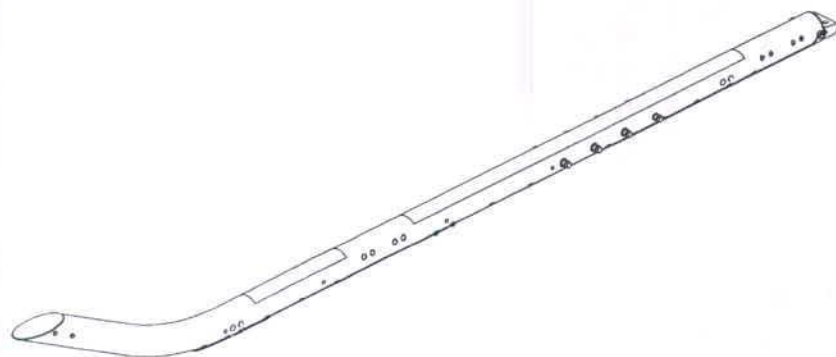
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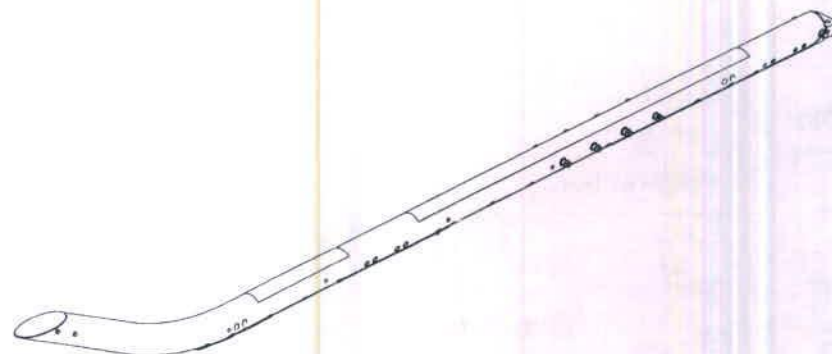
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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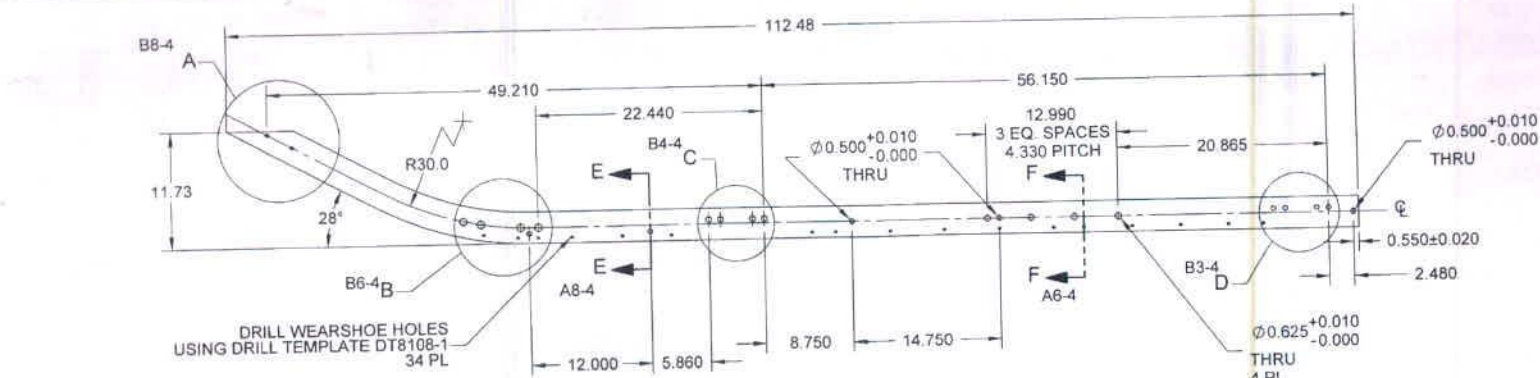
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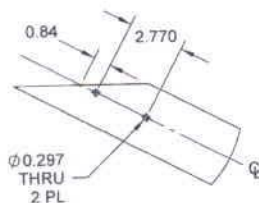
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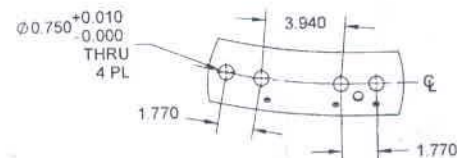


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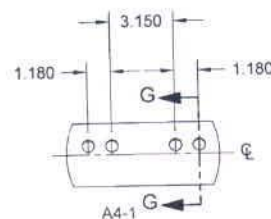
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D7-4



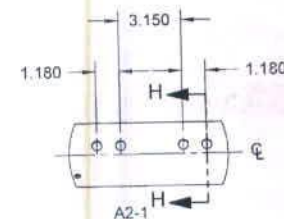
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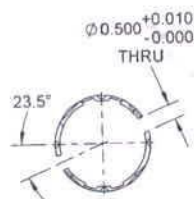
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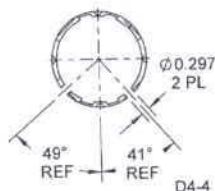
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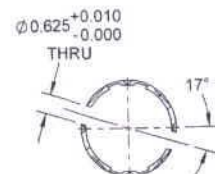
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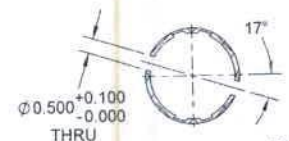
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D4-4



SECTION G-G
SCALE 3X, 4 PL

B4-4



SECTION H-H
SCALE 3X, 4 PL

B2-4

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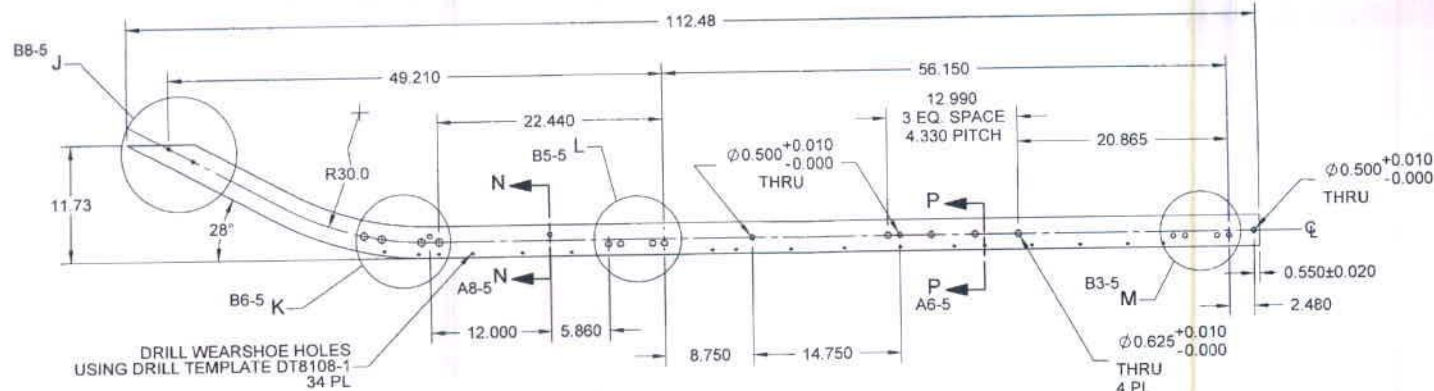
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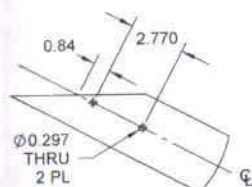
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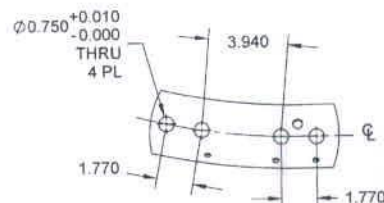
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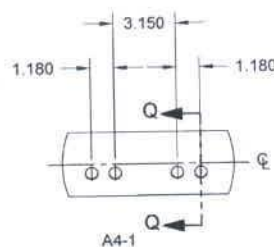
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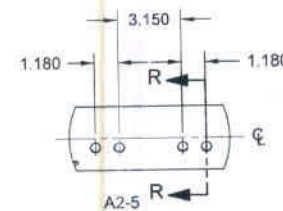
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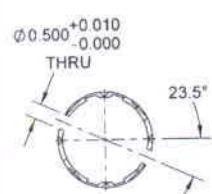
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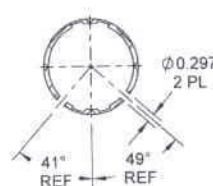
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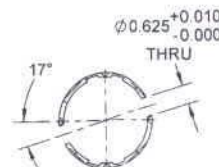
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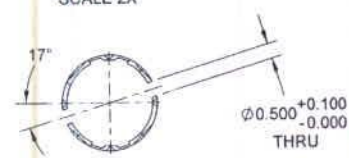
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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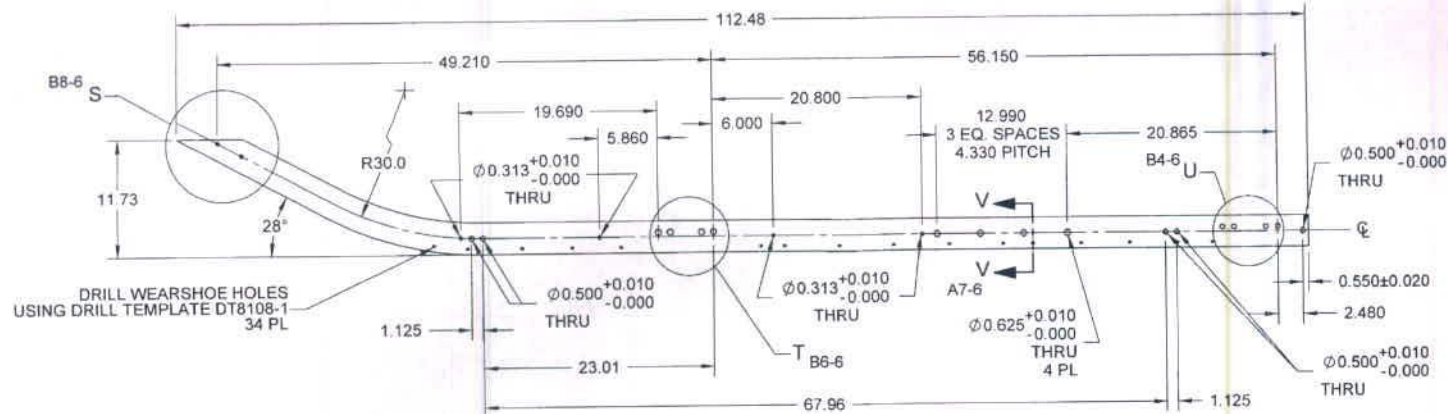
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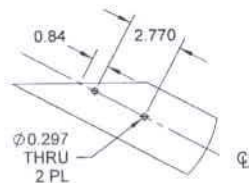
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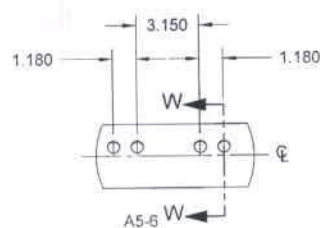
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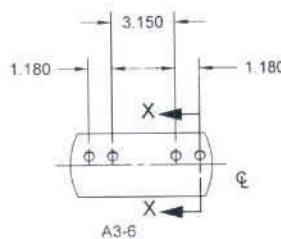
D2750-3 LH SKIDTUBE



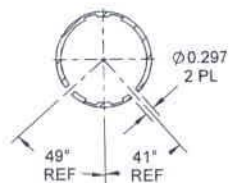
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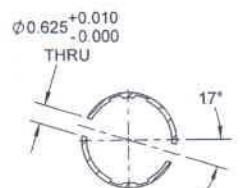
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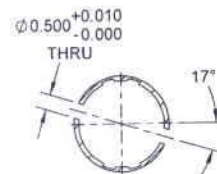
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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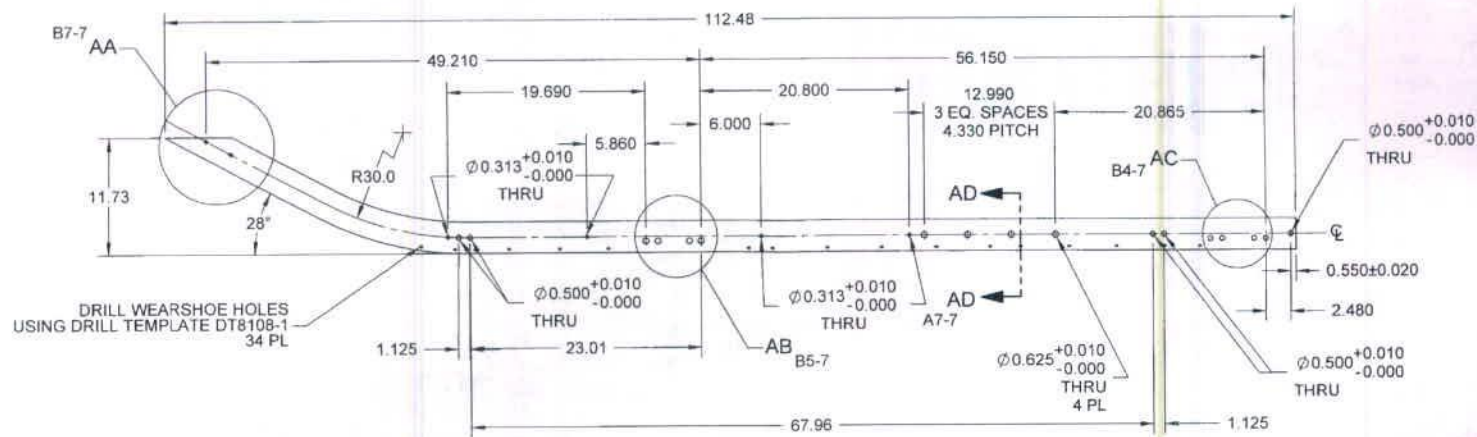
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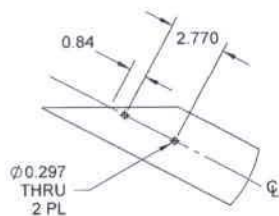
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			Initial Chief Eng	Action Description Chief Eng				

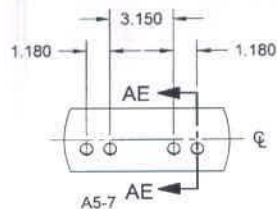
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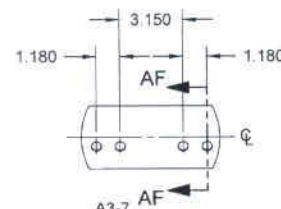
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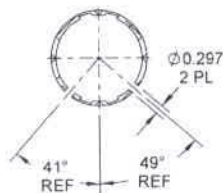
DETAIL AA
SCALE 2X



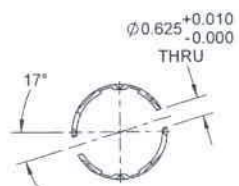
DETAIL AB
SCALE 2X



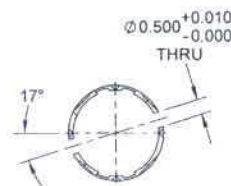
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
06-04-2010

DESIGN	<i>W1055926</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. F
MFG. APPR.	<i>[Signature]</i>		SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

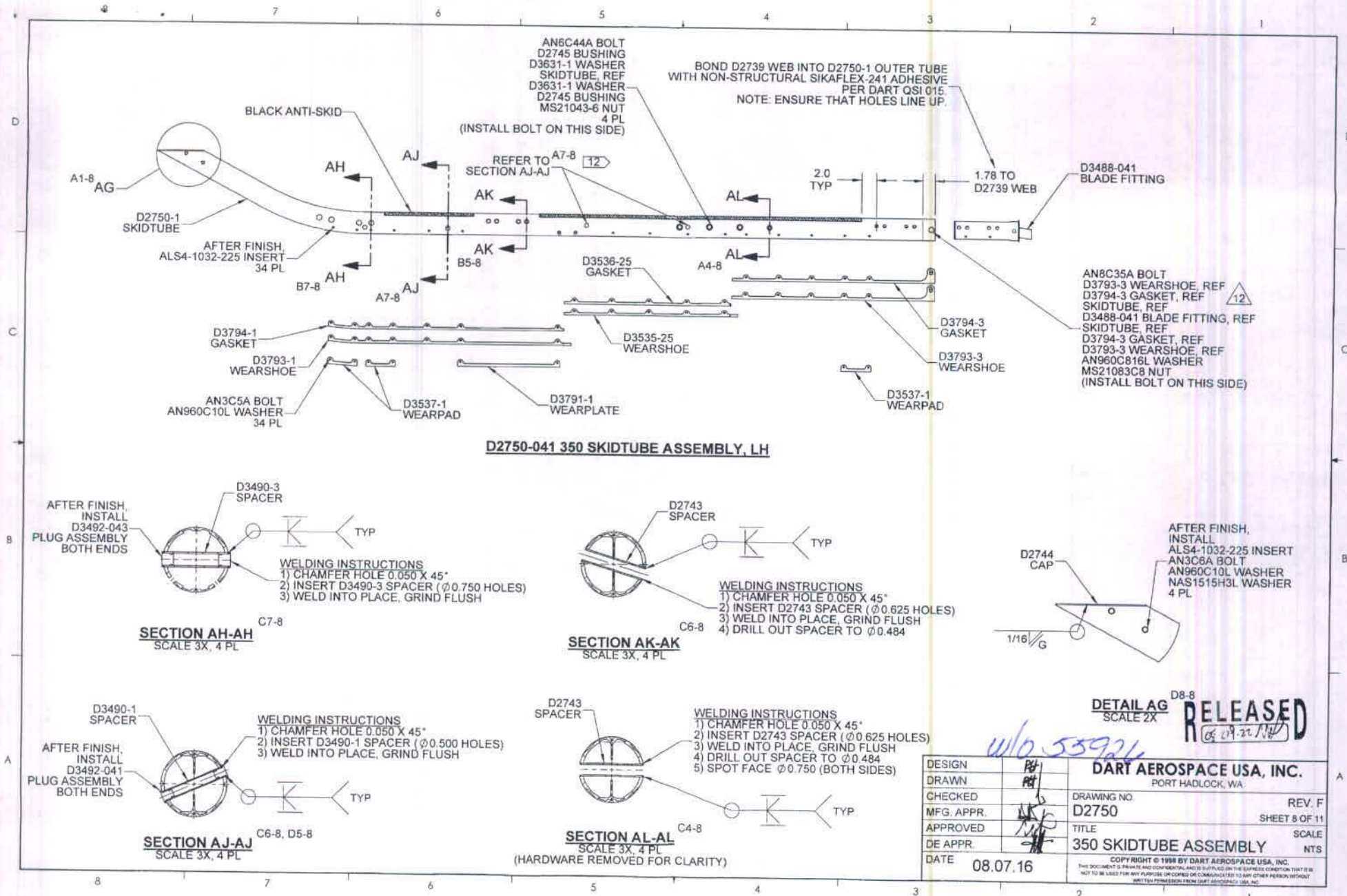
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

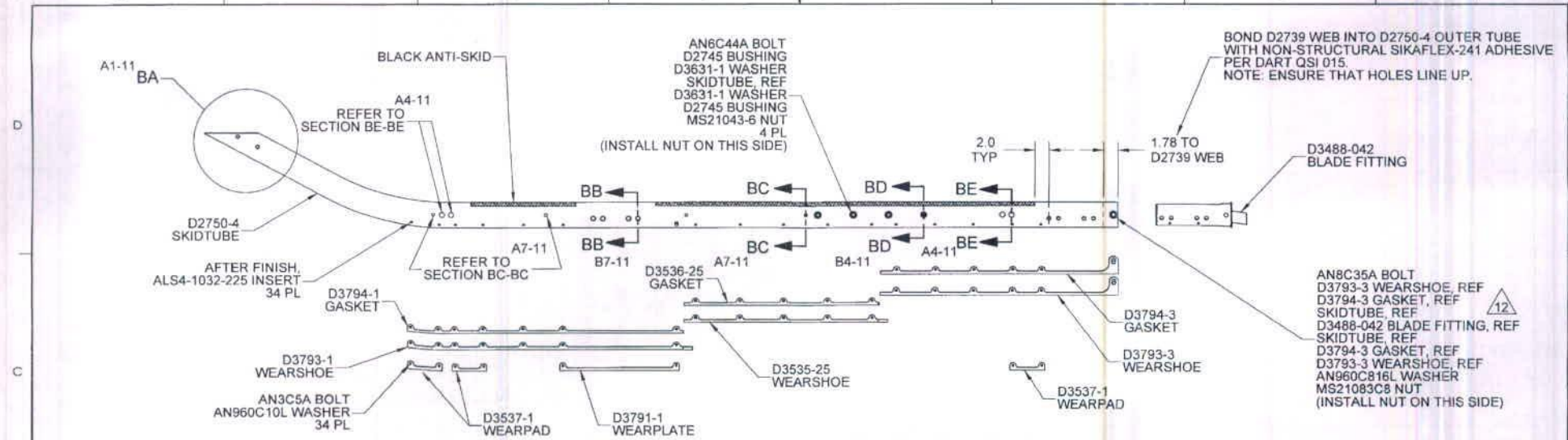
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

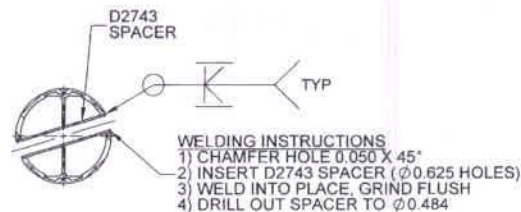
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

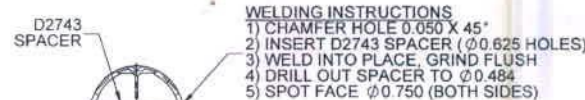
8 7 6 5 4 3 2 1



D2750-044 350 SKIDTUBE ASSEMBLY, RH



SECTION BB-BB
SCALE 3X, 4 PL



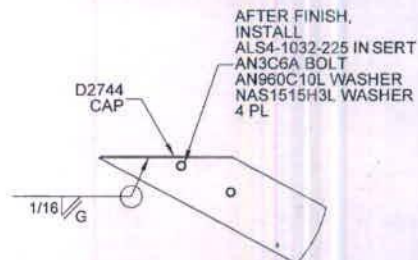
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

RELEASED

DESIGN	W/055926	DART AEROSPACE USA, INC.	
DRAWN	W/055926	PORT HADLOCK, WA	
CHECKED	W/055926	DRAWING NO.	REV. F
MFG. APPR.	W/055926	D2750	SHEET 11 OF 11
APPROVED	W/055926	TITLE	SCALE
DE APPR.	W/055926	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott

Job number: 50276

Part number: D350-62-03

Description: 350 skid tube

Welding Process: Tig[☒] Mig[]

Base material: Aluminum

Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pat. D. L.

Date of Test Coupon 10.02.19

Welder Barclay Elliott

Date of Test Coupon 16.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

